



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-451
Job Sheet 197366



Part No: D206-642-451

Job Qty: 1 pcs

Part Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/5/19

Job Tracking No:

Due Date: 7/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4361-043 REV A SHEETS 1,3,4, IIN-D206-642 REV Q SHEETS 31-32 IPP REV:A NEW ISSUE 13-06-13 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/29/19		0.00	3.70	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
115	QC 5	1 pcs	7/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
116	QC 10	1 pcs	7/29/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		

BE

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JUL 22 2019

7/5/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120	Handfinish - 1-1 Chemical-B4B	1 pcs	7/29/19	0.00 0.74	QC 10 - 9	
					Handfinish - 1 - 1 - B4B	ML 19-7-23
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
130	QC 7	1 pcs	7/29/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	MG
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	

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					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					Skidtubes - 1 - B4B	
140 Skidtubes - 2 - B4B	1 pcs	7/29/19	0.00 3.70		Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	MLG
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
150 QC 5	1 pcs	7/29/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
160 Skidtubes - 3 - B4B	1 pcs	7/29/19	0.00 3.70		Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	TE
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
					QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	DAS
180 QC 10	1 pcs	7/29/19	0.00 0.00		QC 10 - 58	JUL 26 2019 50
					QC 10 - 9	9-89
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
190 QC 5	1 pcs	7/29/19	0.00 0.00		QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	DAS
					QC 5 - 68	JUL 26 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	

200 Handfinish - 2-1 Pressure- B4B	1 pcs	7/29/19	0.00 0.50	QC 5 - 40	
				Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
210 Powdercoat - 1 White GI(A)- B4B	1 pcs	7/29/19	0.00 0.22	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
220 QC 3	1 pcs	7/29/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
230 Handfinish - 4-1-Assembly- B4B	1 pcs	7/29/19	0.00 0.74	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	7/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	

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					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
250	Packaging 3-1 - Stock - B4B	1	7/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
255	DC - 1 - B4B	1	7/29/19	0.00 0.00	DC - 1 - B4B	
	pcs				DC - 2 - B4B	
260	QC 21 - FG	1	7/29/19	0.00 0.00	QC 21 - FG - 21	
	pcs				QC 21 - FG - 70	
					QC 21 - SA - 53	

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Part Op 110 - (Skidtubes) 1-Deburr Fwd edge of tube 3-Weld Fwd Cap as per Dwg D4361. Use aluminum rod. Grind D2647 to fit
 Descriptions: as required. 5-Cut aft end to length from front of tube 6-Drill pilot holes using drill jig DT8025 & DT8169 A-B-C-D 8-Open
 Aft cap hole using # 6 drill bit 9-Open holes for Tow Ring to Ø0.625" as per Dwg D4361, D4361-043 Drilling Detail
 115 - (QC5- Inspect part completeness to step on W/O)
 116 - (QC10- Inspect visual per QSI004- ground welds)
 120 - (Chemical Conversion Coat per QSI005 4.1)
 130 - (QC7-Inspect Chemical Conversion Coat)
 140 - (Skidtubes) 1-Open holes to finished size as per Dwg D4361, D4361-043 Drilling Detail (without cutting fluid) 2-
 Countersink crossbolt spacer holes as per Dwg D4361 (without cutting fluid) 4-Bond D2654-7 web in place as per QSI
 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

- 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Skidtubes) 1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D4361. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
 180 - QC10- Inspect visual per QSI004- ground welds)
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.
 210 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.
 220 - (QC3- Inspect Part Finish)
 230 - (Assemble as per dwg) 1-Install wearplates as per dwg D4361. 7-Wing Walk as per Dwg D4361-043 and QSI 005 4.4
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - Identify and pack for shipping as per PPP D206-642-451
 255 - (Document Control) Photocopy bluefile and create labels per PPP D206-642-451 CHG001
 260 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	110-Skidtubes - 1	0111 38
D2647	Cap	1 pcs (1 ea)	110-Skidtubes - 1	S189572
D2654-7	Web	1 pcs (1 ea)	140-Skidtubes - 2 - B4B	S166098
D2649	Cross Bolt Spacer	26 pcs (26 ea)	160-Skidtubes - 3 - B4B	S086147
AN3-36A	Bolt	10 Ea (10 ea)	230-Handfinish - 4-1-Assembly-B4B	S188472
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B	F11133011
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B	S099573
D2646	Aft Cap	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	F11137886-0
D2651-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	S160607
D2651-3	O-Ring	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	S196041
D2680-041	Nut Plate	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	S186320
D3873-1	Bushing	20 pcs (20 ea)	230-Handfinish - 4-1-Assembly-B4B	S197216
D4366-041	Run-on Landing Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	x S050172
D4366-043	Run-on Landing Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	x S1701688
MS21042-3	Nut use MS21042L3 per QSI 017	10 Ea (10 ea)	230-Handfinish - 4-1-Assembly-B4B	S149299
MS27039-1-08	Screw	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B	S162897
MS27039-4-06	Screw	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	S166974-14
NAS1149C0332R	Washer (AN960C10L)	10 Ea (10 ea)	230-Handfinish - 4-1-Assembly-B4B	S193126
NAS1149D0332J	Washer	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B	S178378
NAS1149D0463J	Washer	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	S055957

(x4) S201769

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	9	0
	D2647	1	34	0
140-Skidtubes - 2 - B4B	D2654-7	1	6	0
160-Skidtubes - 3 - B4B	D2649	26	111	0
230-Handfinish - 4-1-Assembly-B4B	AN3-36A	10	79	0
	CCR264SS3-3	2	179	0
	CR3212-4-03	2	74	0
	D2646	1	25	0
	D2651-1	8	371	0
	D2651-3	8	291	0
	D2680-041	1	2	0
	D3873-1	20	94	0
	D4366-041	1	0	0
	D4366-043	1	0	0
	MS21042-3	10	513	0
	MS27039-1-08	2	421	0
	MS27039-4-06	1	91	0
	NAS1149C0332R	10	4,682	0
	NAS1149D0332J	2	3,250	0
	NAS1149D0463J	1	2,863	0

Part Specifications	
Specifications could not be found.	

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1 2 3 4 5 6 7 8

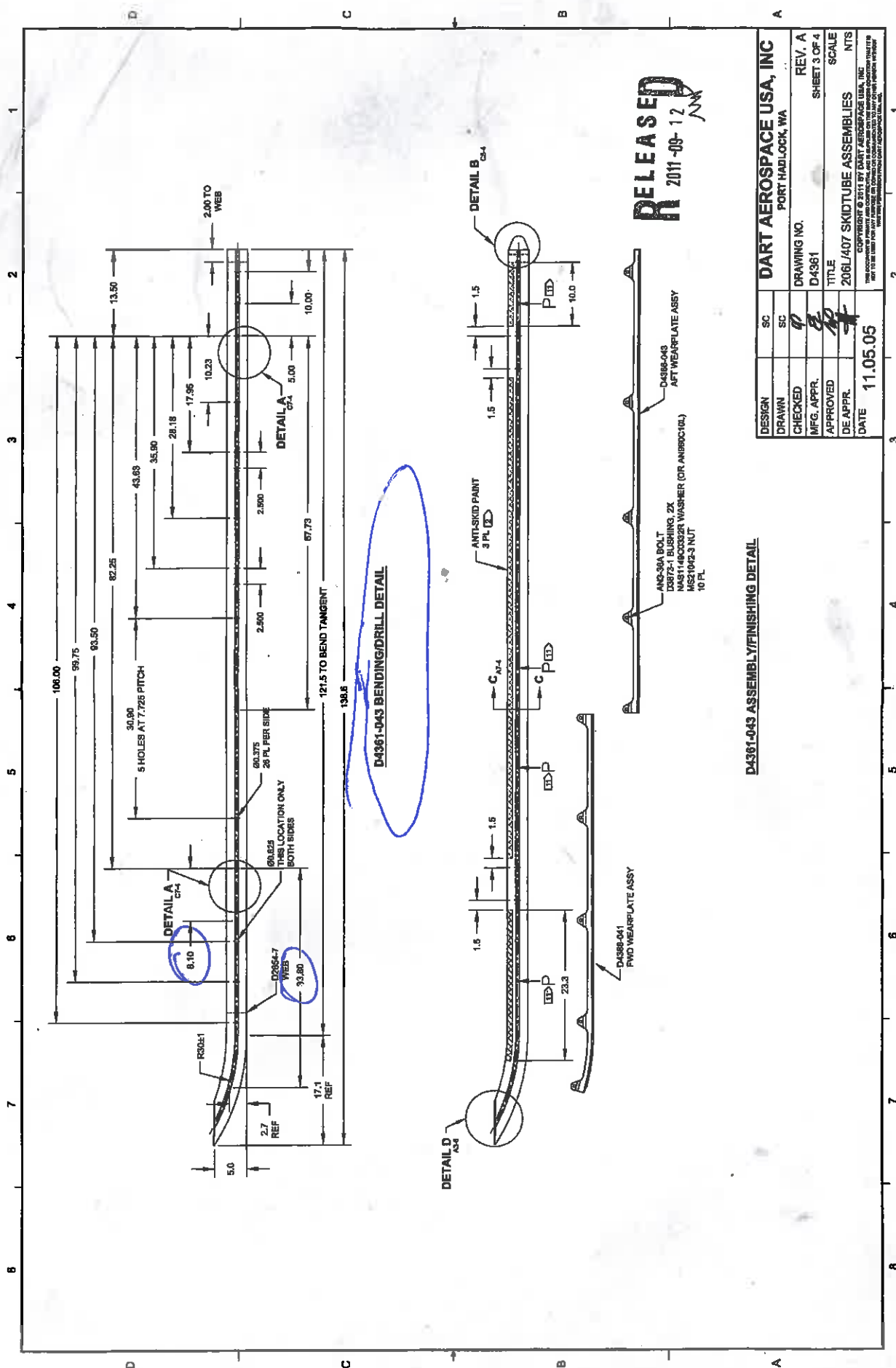
QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
X	X	D4361-041	SKIDTUBE ASSY
		D4361-043	SKIDTUBE ASSY
1	1	D2600-1-180	EXTRUSION
1	1	D2654-5	WEB
1	1	D2654-7	WEB
1	1	D2646	AFT CAP
1	1	D2647	CAP
23	26	D2649	CROSS BOLT SPACER
4	8	D2651-1	PLUG
4	8	D2651-3	O-RING
1	1	D2680-041	NUT PLATE
18	20	D3873-1	BUSHING
1	1	D4364-041	FWD WEARPLATE ASSY
1	1	D4364-043	AFT WEARPLATE ASSY
1	1	D4366-041	FWD WEARPLATE ASSY
1	1	D4366-043	AFT WEARPLATE ASSY
9	10	AN3-38A	BOLT
9	10	NAS1149C0332R	WASHER (OR AN980C10L)
9	10	M821042-3	NUT
2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
2	2	CCR2646S3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	M827039-1-08	SCREW
1	1	M827039-4-08	SCREW
1	1	NAS1149D046SJ	WASHER (OR AN980JD416)

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WORK ORDER
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RELEASED
2011-09-12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2654-5-7 WEB
-POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D4361-041 = 37.5 LBS
D4361-043 = 44.3 LBS
 - 8) WELD PER DART QSI 004
 - 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
 - 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
 - 11) INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

A	NEW ISSUE	DESCRIPTION	SC	BY	DATE
REV.					
DESIGN	SC				
DRAWN	SC				
CHECKED	SC				
MFG. APPR.	SC				
APPROVED	SC				
DE APPR.	SC				
DATE	11.05.05				
DART AEROSPACE USA, INC PORT HADLOCK, WA					
DRAWING NO. REV. A					
D4361 SHEET 1 OF 4					
TITLE					
206L407 SKIDTUBE ASSEMBLIES					
SCALE					
NTS					
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RELEASED
2011-09-12

D4361-043 ASSEMBLY/FINISHING DETAIL

DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>go</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>go</i>	D4361	SHEET 3 OF 4
APPROVED	<i>go</i>	TITLE	SCALE
DE APPR.	<i>go</i>	2061/407 SKIDTUBE ASSEMBLIES	NTS
DATE 11.05.05		COPYRIGHT © 2011 BY DART AEROSPACE USA, INC ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Eng. (Non-AW) ☐ Machining ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐																														
Date: 15/7/10		Sequence #: _____		QTY Affected: _____		MRB (QSI042) INSP 12 4/14/10																												
Description Work Order Deviation Ø 0.625 tooling hole is too small for leg				Disposition Ø 0.625 hole on dwg to be drilled Ø 0.640																														
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____			Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																															
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																															
Crushing	BOM/Route	Grain Direction	Drawing																															
Cracks	Broken/Damage/Defect	Weld	Finish																															
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing																															
Marks/Chatter	Drill Holes	Out of Sequence	Misread																															
Mislabeled	Fit/Function	Off-set/Set-up																																
				Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator 40 9-89 212200																														